

# Work Order ID 111286

Friday, January 10, 2014 9:10:33 AM

**\*111286\***

Page 1

Item ID: D350-689-015 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Seat Modification  
 Start Date: 1/10/2014 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 1/17/2014 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: mf Date: 14-01-10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3033	Rev A1								
100	DOCUMENT CONTROL	0.00	DAS	6					
<b>*100*</b>			9-89	14-2-11					
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-689-015 CHG001								
150	Pick Kit	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
<b>*160*</b>			DAS	6					
QC	Memo	0.00	9-89						
Quality Control									

ML5 14-01-13

4X

41

DAS

31

9-89

DAS

33

9-89

14-01-10

45

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 111286**

Friday, January 10, 2014 9:10:33 AM

**\*111286\***

Page 2

Item ID: D350-689-015

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Seat Modification

Start Date: 1/10/2014 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/17/2014 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

0.00

**\*170\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP d350-689-  
015 Location: 041 PPP Rev: BHD B 14-02-11

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLJ 14-02-11D 14-02-11

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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### FAULT CATEGORY

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# Picklist Print

Friday, January 10, 2014 9:10:32 AM

Page 1

Work Order ID: 111286  
Parent Item: D350-689-015  
Parent Item Name: Seat Modification

Start Date: 1/10/2014 Required Date: 1/17/2014  
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP Rev:A04.03.25New IssueKJ/RF IPP REV:B 12.01.05 REMOVE MS20426AD3-6  
DD VERF:EC IPP REV:C 13.11.26 add missing(2) MS27039-1-10 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3033-1 Seat Track	(4) DAS 6 9-89	Manufactured	No			160	Each	0.0000	1	4			DAS 31 9-89
D3029-1 Spring		Manufactured	No			160	Each	10.0000	2	8			DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA	105583	10							
						10							
D3030-1 Lock	DAS 6 9-89	Manufactured	No			160	Each	2.0000					DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST023	97713	2							
						2							
D3059-1 Stud	DAS 6 9-89	Manufactured	No			160	Each	2.0000					DAS 32 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST024	46491	2							
						2							
D3060-1 Bushing	DAS 6 9-89	Manufactured	No			160	Each	12.0000					DAS 31 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST024	24725	12							
						12							
D3061-1 Radius Block		Manufactured	No			160	Each	2.0000					DAS 32 9-89
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST024	22349	2							
						2							

3x B110774

1x B109531

6x 111093

2x 108083

8x B110211

16x 109408

4x 111290

2x 46491

4x B111401

10x 24725

19x 109568

2x 22349

DAS  
31  
9-89

DAS  
32  
9-89

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Transport									
Unapproved									

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

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Doc/Data									
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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

Friday, January 10, 2014 9:10:33 AM

Page 3

Work Order ID: 111286

Parent Item: D350-689-015

Start Date: 1/10/2014

Required Date: 1/17/2014

Parent Item Name: Seat Modification

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Washer

Purchased No

160

Each

1,977.0000

12

DAS

33

9-89

DAS  
6  
9-89

## Location

## Loc Qty

## Loc Code

ST293

577

m127431

577

ST294

10

m125807

10

ST510a

1390

m127374

390

m127389

1000

127431

DAS  
31  
9-89

NAS1149D0563J

Washer

Purchased No

160

Each

813.0000

16

DAS

33

9-89

14-01-10

## Location

## Loc Qty

## Loc Code

GA

273

m125807

273

ST510a

540

m126319

540

126319

DAS  
31  
9-89

DAS  
6  
9-89

Friday, January 10, 2014 9:10:33 AM

Shop Packet Print

Page 3

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

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Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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#### 4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011 Dual High Back Seat Installation, Fwd Position	27.6 lb 12.5 kg	-18.2 in -0.46 m	-502 in-lb -5.8 m-k-g	60.7 in 1.54 m	1675 in-lb 19.3 m-k-g
D350-689-013 Floor Provisions Kit, Fwd Position	2.0 lb 0.9 kg	-18.2 in -0.46 m	-36 in-lb -0.4 m-k-g	60.7 in 1.54 m	121 in-lb 1.4 m-k-g
D350-689-011 Dual High Back Seat Installation, Aft Position	28.1 lb 12.7 kg	-18.2 in -0.46 m	-511 in-lb -5.8 m-k-g	63.7 in 1.62 m	1790 in-lb 20.57 m-k-g
D350-689-013 Floor Provisions Kit, Aft Position	3.1 lb 1.4 kg	-18.2 in -0.46 m	-56 in-lb -0.6 m-k-g	62.2 in 1.58 m	193 in-lb 2.2 m-k-g
D350-689-015 Seat Modification Kit	1.0 lb 0.5 kg	-17.2 in -0.44 m	-17 in-lb -0.22 m-k-g	60.7 in 1.54 m	61 in-lb 0.77 m-k-g
D350-689-017 Shoulder Harness, Fwd Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-k-g	60.7 in 1.54 m	267 in-lb 3.08 m-k-g
D350-689-017 Shoulder Harness, Aft Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-k-g	64.7 in 1.64 m	285 in-lb 3.28 m-k-g
D350-689-019 Control Guard, Fwd Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-k-g	60.7 in 1.54 m	30 in-lb 0.35 m-k-g
D350-689-019 Control Guard, Aft Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-k-g	64.7 in 1.64 m	32 in-lb 0.38 m-k-g
D350-689-021 Dual High Seat Back Installation, LH Fwd Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-k-g	60.7 in 1.54 m	1772 in-lb 20.3 m-k-g
D350-689-021 Dual High Seat Back Installation, LH Aft Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-k-g	64.7 in 1.64 m	1889 in-lb 21.6 m-k-g
D350-689-023 Energy Attenuating Floor Provisions Kit	2.5 lb 1.1 kg	-18.2 in -0.46 m	-46 in-lb -0.5 m-k-g	62.2 in 1.58 m	156 in-lb 1.7 m-k-g

#### 5. PARTS LIST

Qty -011	Qty -013	Qty -045	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
									D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
							2	2	D3016-041	SEAT FRAME ASSEMBLY
							1	1	D3017-041	BACK FRAME ASSEMBLY
1					1				D3018-1	SEAT CUSHION
1					1				D3019-1	BACK CUSHION
							1	1	D3021-041	TUBE ASSEMBLY
							1	1	D3022-1	SEAT PAN
							1	1	D3023-1	BACK PANEL
							3	3	D3024-1	SPACER
	1								D3025-1	BEAM

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Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
	1					1			D3026-1	CHANNEL
	1								D3027-1	CLIP
	1								D3027-3	CLIP
	1								D3027-5	CLIP
	4					4			D3027-7	CLIP
							4		D3028-1	STUD
		2					2		D3029-1	SPRING
		2					2		D3030-1	LOCK
							2	2	D3031-1	LOOP
	1								D3032-1	SPACER
	2	1							D3033-1	SEAT TRACK
		4							D3059-1	STUD
		4							D3060-1	BUSHING
		4							D3061-1	RADIUS BLOCK
		4							D3084-3	STRUT
	1			1					D3234-1	DOUBLER
	1					1			D3234-3	DOUBLER
	2								D3234-5	SPACER
								2	D3808-041	SEAT RAIL ASSEMBLY
								4	D3809-1	SLIDING BLOCK
						1			D3811-041	SEAT TRACK ASSEMBLY
			2						D4071-041	SHOULDER HARDNESS ASSY
								3	AN3-12A	BOLT
				1					AN4-12A	BOLT
				1					AN4-20A	BOLT
			2						AN5-4A	BOLT
								40	MS20600AD4W2	RIVET
								6	MS20600AD4W3	RIVET
						9	17	17	MS21042L3	NUT (OR MS21042-3)
		4		2			6	6	MS21042L4	NUT (OR MS21042-4)
		4	2						MS21042L5	NUT (OR MS21042-5)
12									MS21059L3	NUTPLATE
		1						4	MS24693-S272	SCREW
2									MS24693-S273	SCREW
								8	MS24694-S3	SCREW
						9			MS24694-S50	SCREW
								4	MS24694-S148	SCREW
6		3							MS27039-1-10	SCREW
							4	4	MS27039-1-17	SCREW
							6	6	MS27039-1-19	SCREW
							6	6	MS27039-4-21	SCREW
6		3					17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
						9			NAS1149D0363J	WASHER (OR AN960JD10)
				8					NAS1149D0416J	WASHER (OR AN960JD416L)
							6	6	NAS1149D0432J	WASHER (OR AN960JD416)
			4						NAS1149D0516J	WASHER (OR AN960JD516L)
		4							NAS1149D0563J	WASHER (OR AN960JD516)
				2					NAS43994-46N	SPACER

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